

Ship Feb. 4

Work Order ID 96053-4

January-18-13 9:59:56 AM

96053

~~U/R~~

Page 1

Item ID: D3705-041

Revision ID: U/R OK

Item Name: Instrument Panel Assembly

Start Date: 1/18/13

Start Qty: 2.00

2

Required Date: 2/01/13

Req'd Qty: 2.00

2

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLJ

Date: 13-01-18

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3705

E

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble parts as per dwg D3705

110

0.00

110

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

120

0.00

120

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

Packaging

FF
13-02-20
1
1
13/1/21
13/1/21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 96053

January-18-13 9:59:56 AM

96053

Page 2

Item ID: D3705-041
Revision ID: U/R
Item Name: Instrument Panel Assembly

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/18/13 Start Qty: 2.00 *2*

Required Date: 2/01/13 Req'd Qty: 2.00 *2*

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/2/26

MF

13-2-25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

January-18-13 9:59:59 AM

Page 1

Work Order ID: 96053

96053

Parent Item: D3705-041

D3705-041

Parent Item Name: Instrument Panel Assembly

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
 IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec
 IPP Rev:C 09-01-15 rivet chg DD verified by:EC IPP rev:D
 10.04.21 washer chg per NCR10-017 DD verified by:EC
 IPP Rev:E as per dwg RevD DD 10.04.27 verified by:EC IPP REV:F
 12.12.03 REV PE1 DD VERF:JLM IPP REV:G 13.01.15
 AS PER DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-1 *D3335-1* Short Spring		Manufactured	No			100	Each	0.0000	1	2			
							96050		**	2		FF 13-02-21	
D3705-043 *D3705-043* Instrument Panel Weldment		Manufactured	No			100	Each	0.0000	1	2			
							96054		**	2		FF 13-02-21	
D3705-5 *D3705-5* Access Panel		Manufactured	No			100	Each	5.0000	1	2			
									**			FF 13-02-21	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			2			
					ST063 95132	5							
					54825	3							
					90127	2							
D3706-041 *D3706-041* Lock Bracket Assembly		Manufactured	No			100	Each	0.0000	1	2			
							195729		**			FF 13-02-21	
D3706-5 *D3706-5* Pin		Manufactured	No			100	Each	3.0000	1	2			
									**			FF 13-02-21	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST063	3							
					56914	3				2			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Picklist Print

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Page 2

Work Order ID: 96053

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

96053

D3705-041

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 2.00

Required Qty: 2.00

D3707-3

Manufactured No

100 Each 7.0000 2 4

D3707-3

Mounting Lug

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST063

96127

7

4

56915

7

AN3-3A

Purchased No

100 Each 436.0000 2 4

AN3-3A

Bolt

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST350

436

123352

36

123831

200

124221

200

AN526C1032R6

Purchased No

100 Each 725.0000 4 8

AN526C1032R6

Screw

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST346

725

1892

725

AN960JD516

NAS1149D0563J

Purchased No

100 Each 2.0000 1 2

AN960JD516

Washer

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST504

122452

2

2

1069059

2

January-18-13 10:00:00 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
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FAULT CATEGORY												
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Picklist Print

January-18-13 10:00:00 AM

Page 3

Work Order ID: 96053

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

96053

D3705-041

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 2.00

Required Qty: 2.00

CR1122-3-02.5

Purchased

No

100

Each

195.0000

28

56

CR1122-3-02 5

RIVET

**

FF 13-02-21

Location

Loc Qty

Loc Code

GA

52

122518

52

ST327

143

122845

43

124259

100

42

MS171498

Purchased

No

100

Each

42.0000

1

2

MS171498

Spring Pin

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST331

42

108521

42

2

MS21075L3

Purchased

No

100

Each

43.0000

14

28

MS21075L 3

Nutplate

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST318

43

123832

43

16

12

MS24693-C272

Purchased

No

100

Each

1,252.000

4

8

MS24693-C272

Screw

**

FF 13-02-21

Location

Loc Qty

Loc Code

ST300

1252

17137

467

17831

519

9370

266

8

January-18-13 10:00:00 AM

Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

January-18-13 10:00:00 AM

Page 4

Work Order ID: 96053

96053

Parent Item: D3705-041

D3705-041

Parent Item Name: Instrument Panel Assembly

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

100

Each

3.118.000

2

4

NAS1149D0332.I

**

Washer

FF 13-02-21

Location

Loc Qty

Loc Code

FP001

328

122973

328

ST294

2790

122973

2790

4

NCR: Yes / No

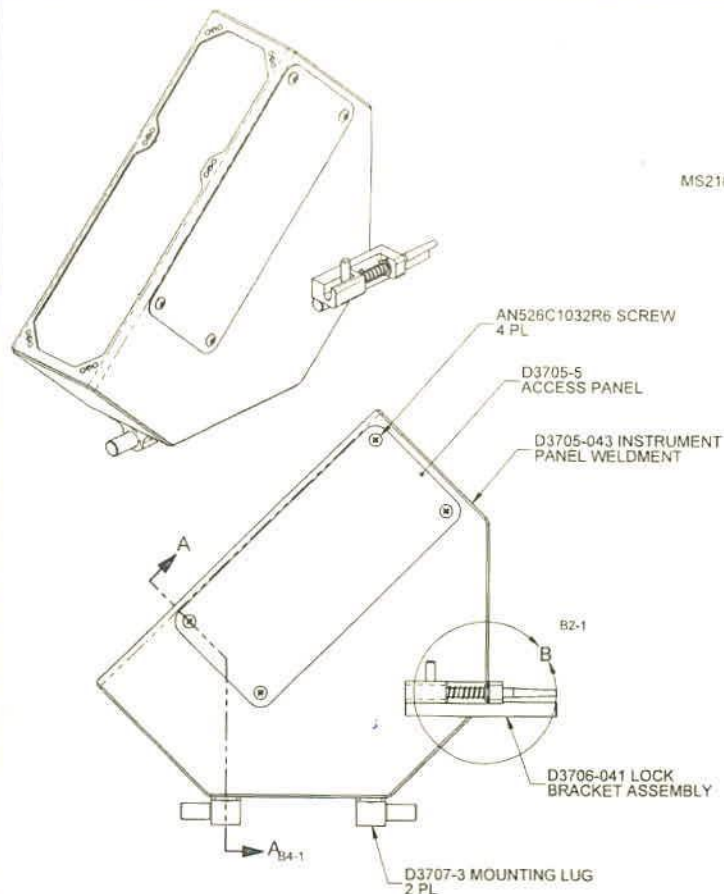
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Rouze <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	



D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 3.20 lbs

MS21075L3 NUTPLATE
REF

AN526C1032R6 SCREW
4 PL

D3705-5
ACCESS PANEL

D3705-043 INSTRUMENT
PANEL WELDMENT

B2-1

D3706-041 LOCK
BRACKET ASSEMBLY

D3707-3 MOUNTING LUG
2 PL

AN3-3A BOLT
NAS1149D0332J WASHER
2 PL

SECTION A-A
SCALE 2X

SECTION G-G
SCALE 2X

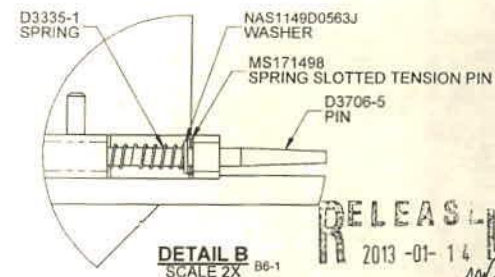


MS21075L3 NUTPLATE, 1X
CR1122-3-02.5 RIVET, 2X
14 PL

MS24693-C272 SCREW
4 PL

D3707-3 MOUNTING LUG
REF

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3705-041	INSTRUMENT PANEL ASS'Y
1	1	D3335-1	SPRING
2	1	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-5	ACCESS PANEL
4	1	D3706-041	LOCK BRACKET ASSEMBLY
5	1	D3706-5	PIN
6	2	D3707-3	MOUNTING LUG
7	2	AN3-3A	BOLT
8	4	AN526C1032R6	SCREW
9	1	NAS1149D0563J	WASHER (OR AN960JD516)
10	28	CR1122-3-02.5	RIVET
11	1	MS171498	SPRING SLOTTED TENSION PIN
12	14	MS21075L3	NUT PLATE
13	4	MS24693C272	SCREW
14	2	NAS1149D0332J	WASHER (OR AN960JD10L)



E	REVISED D3705-1-3 (NOW 0.75 TALLER - AFFECTS -1F2-3F). D3706-1-3 NOW D3706-041 AND BOLTED. ADD AN3-3A BOLT 1. NAS1149D0332J WASHER. D3706-041, 9.88 WAS 9.13 (ZN D1-3, B3-3, C7-4). 6.000 WAS 7.150 (ZN C4-6). 3.20 IN WAS 3.00 IN. REASON: CR12-4PAR12-188.	MB	12.11.30
D	ITEM 14 WAS AN960JD416 (ZN D3-1 AND C1-1). REASON: NCR#10-012.	MB	10.04.15
C	ADDED D3705-7-9/11 (SHEET 6). REMOVED MS35589-156 GROMMET. 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3). 0.190 WAS 1.50 (ZN D5-4). ADDED 0.0204 HOLE (ZN D5-4). CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY. 14 MS21075L3 WAS QTY. 8. QTY. 28 MS20426AD3-3 WAS QTY. 16. MS171498 WAS TP-2. AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1). REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	1/8		
DRAWN	1/8		
CHECKED	1/8		
MFG. APPR.	1/8		
APPROVED	1/8		
DE APPR.	1/8		
DATE	12.11.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. E
SHEET 1 OF 6

TITLE **INSTRUMENT PANEL ASS'Y** SCALE
DE APPR. NTS

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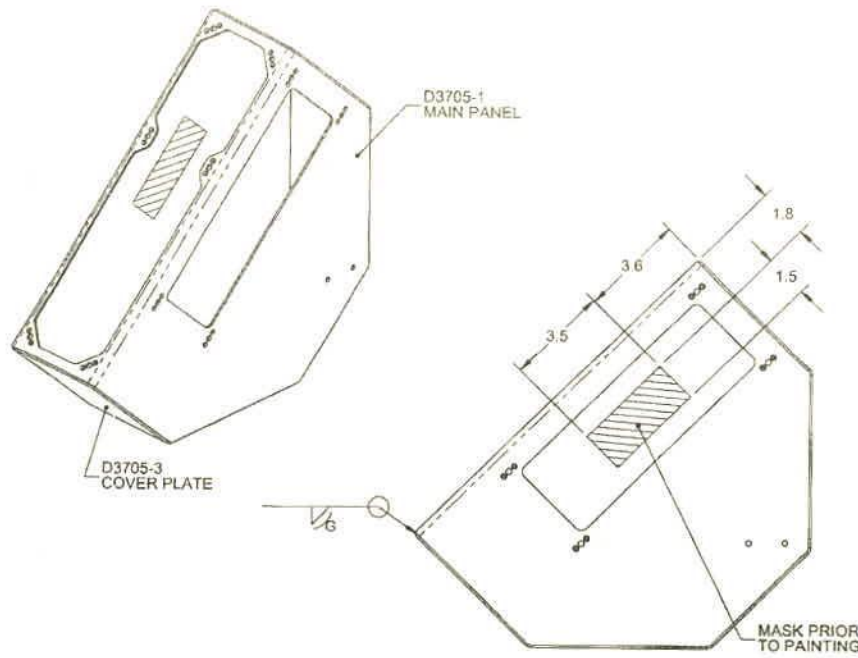
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SUBMITTED TO
WITHOUT E
WORK R

96053 MLJ
13-01-18



96053

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE



D3705-043 INSTRUMENT PANEL WELDMENT

RELEASED
2013-01-14

D3705-043 NOTES:

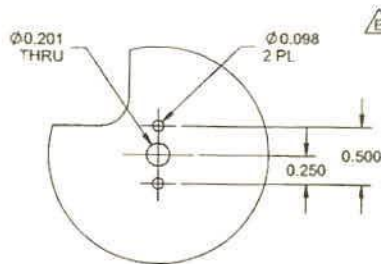
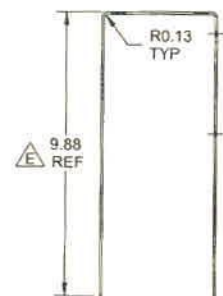
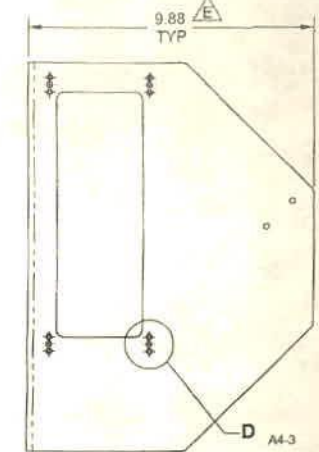
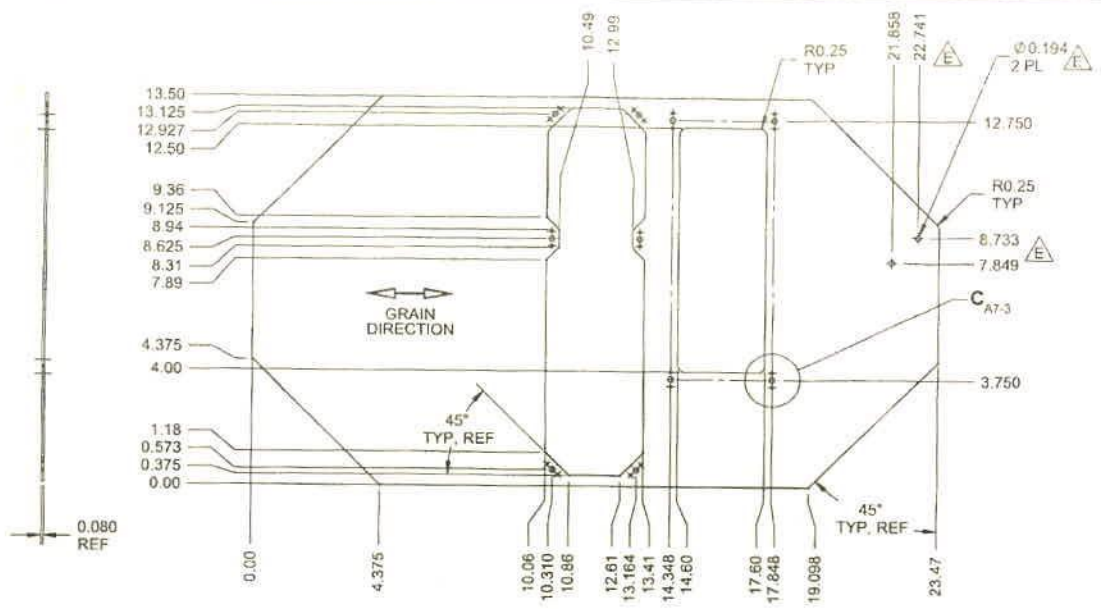
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.11.30

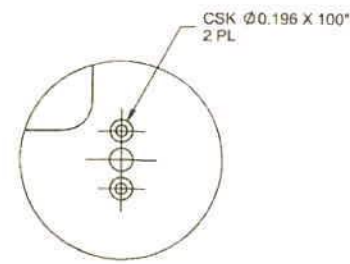
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3705	REV. E SHEET 2 OF 6
TITLE INSTRUMENT PANEL ASS'Y	SCALE NTS
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96053



DETAIL C
SCALE 4X C4-3
10 PL



DETAIL D
SCALE 4X C1-3
10 PL

D3705-1F MAIN PANEL

D3705-1 MAIN PANEL
MAKE FROM D3705-1F

RELEASED
2013-01-14

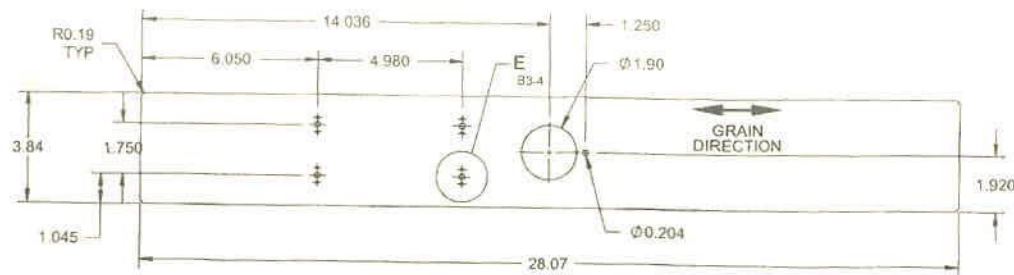
- D3705-1F-1F NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.65 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.11.30

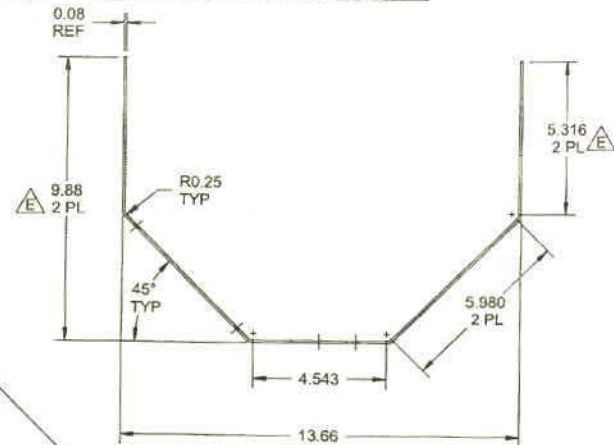
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3705	REV. E SHEET 3 OF 6
TITLE INSTRUMENT PANEL ASS'Y	SCALE NTS
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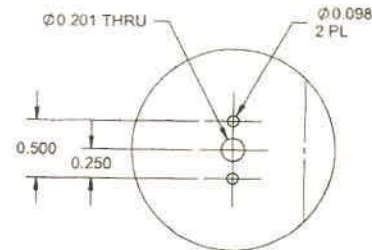
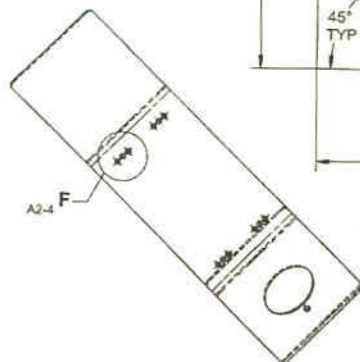
96053



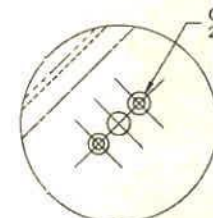
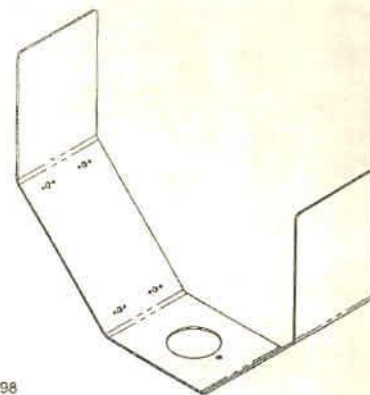
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL E
SCALE 4X
4 PL**



**DETAIL F
SCALE 4X
4 PL**

RELEASE
2013-01-16

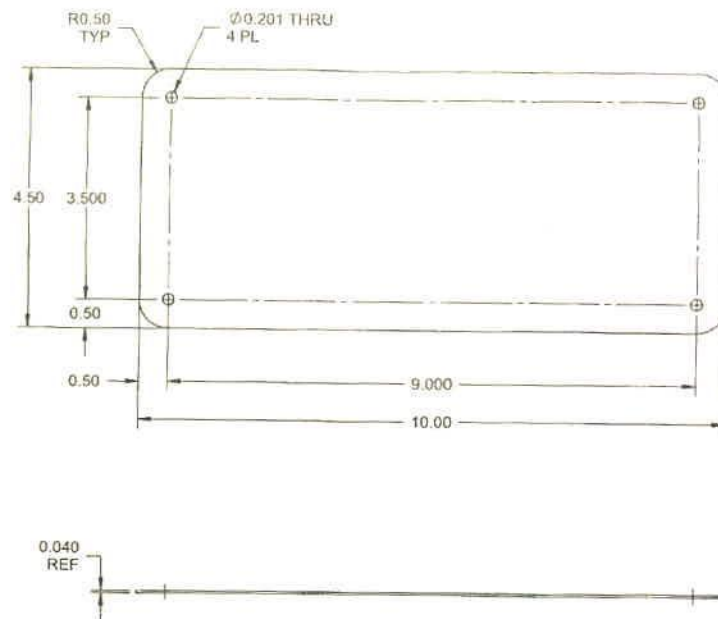
D3705-3/3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
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96053



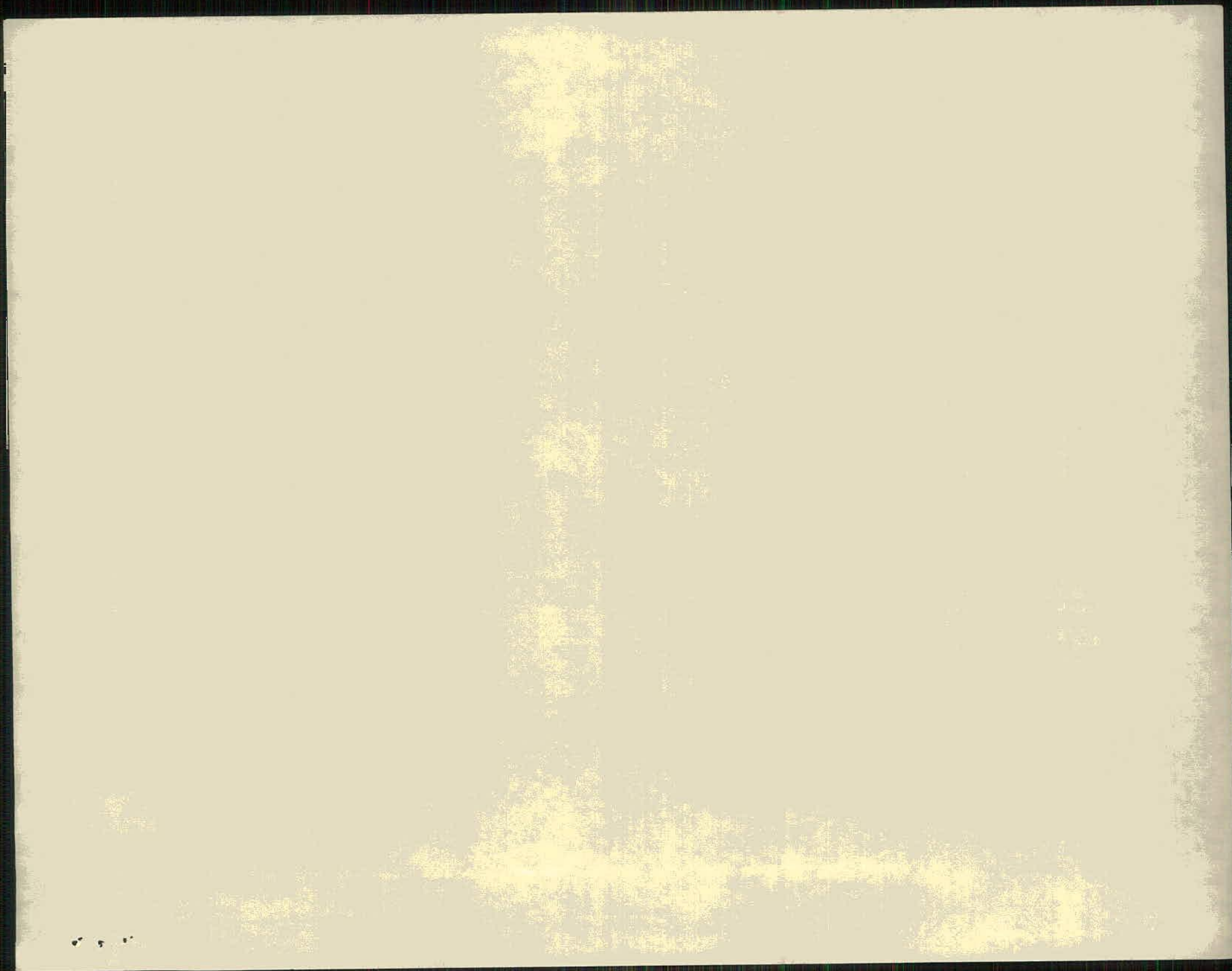
D3705-5 ACCESS PANEL

RELEASED
2013-01-14
MJP

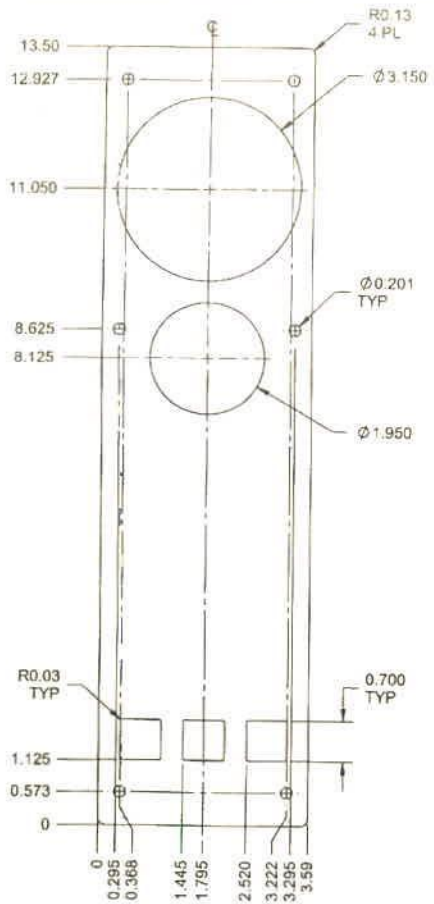
D3705-5 NOTES.

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: 0.17 lbs

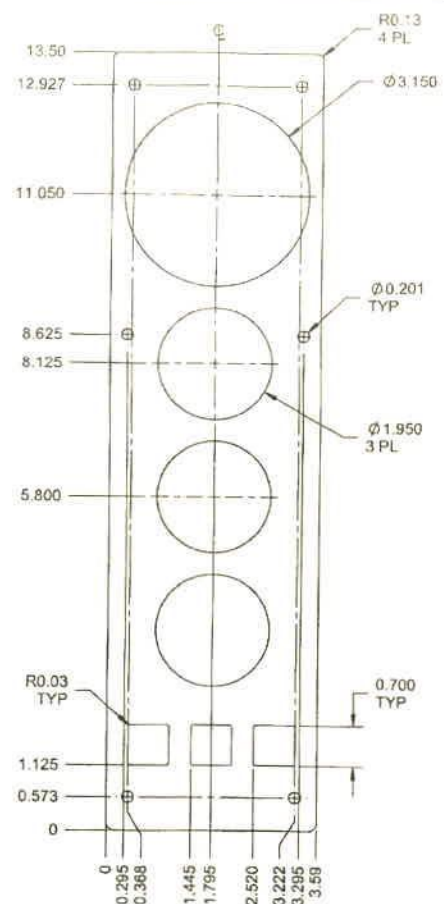
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NT3
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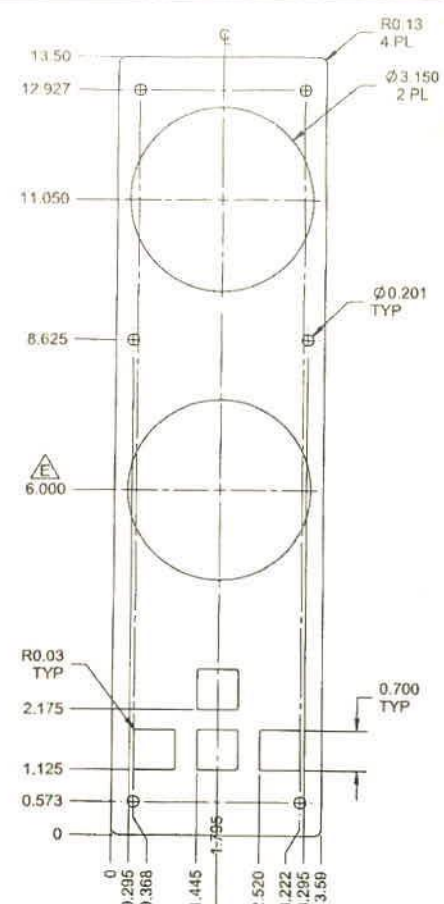
96053



D3705-7 FACE PLATE



D3705-9 FACE PLATE



D3705-11 FACE PLATE



SIDE VIEW TYP

- D3705-7/-9/-11 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
 - 7) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 8 OF 8
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